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DAS
21
9-89

D3772-1
Job Sheet 184620



Part No: D3772-1

Job Qty: 1 ea

Part Name: Back Leg



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/15/18

Job Tracking No:

Due Date: 10/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC IPP Rev:B 08-09-24 Now on Haas JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	10/17/18	10/17/18	0.00	0.00	Start Up Machining-2		Kt 2018-10-22
100	Bandsaw	4 pcs	10/17/18	10/17/18	0.00	0.20	Bandsaw1		Kt 2018-10-22
110	CNC Vertical Machining	4 pcs	10/17/18	10/17/18	0.51	4.55	HAAS1-4		Kt 2018-10-22
120	QC	4 pcs	10/17/18	10/17/18	0.00	0.00	QC2 Machining-2		Kt 2018-10-22
130	QC	4 pcs	10/17/18	10/17/18	0.00	0.00	QC8 Machining-2		mm 8/10/22
140	Small Fab	4 pcs	10/17/18	10/17/18	0.00	4.00	Small Fab-5		10/6/18 P.D. DAS
150	QC	4 pcs	10/17/18	10/17/18	0.00	0.00	QC5		FOR 2.0.2018
160	Packaging	4 pcs	10/17/18	10/17/18	0.00	0.00	Packaging3-1	57255	74 JUN 20 2018
170	QC21-SA	4 Ea	10/17/18	10/17/18	0.00	0.00	QC21		9-89

Part Op 100 - Cut blank 31.500" long

Descriptions: 110 - 1- Mill as per Folio FA787 Rev: _____ & Dwg D3772 Rev: _____

140 - 1-cut tube to length as per dwg D3772 3-bend tube as per dwg D3772

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR1.250W.125	304 Round Tube 1.250 X .125W	10.5008 ft (2.6252 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR1.250W.125	11	35	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Back Leg	0.500Inches ± 0.030	0.530 0.470		
2	Back Leg	1.700Inches ± 0.030	1.730 1.670		
3	Back Leg	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
4	Back Leg	12.560Inches ± 0.030	12.590 12.530		

P.T.O.

NCR: 19-7258

5	Back Leg	0.323Inches + 0.006 - 0.000	0.329 0.323	Diameter
6	Back Leg	0.323Inches + 0.006 - 0.001	0.329 0.322	Diameter
7	Back Leg	1.250Inches ± 0.010	1.260 1.240	Diameter
8	Back Leg	0.125Inches ± 0.010	0.135 0.115	
9	Back Leg	1.100Inches ± 0.030	1.130 1.070	
10	Back Leg	0.323Inches + 0.006 - 0.001	0.329 0.322	Diameter

Plex 10/15/18 12:19 PM Dart.lajeunesse.marie



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Container No: S120047



Part: D3772-1
Job No: 184620
Serial No/Batch: S120047
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 10/22/18

